

# EXPERIMENT AND DEVELOPMENT ORDER

Prepared By: J. Zheng  
Requested By: K. Lind  
Date:   
Industry: Meat  
Customer: Not to Ship  
Shipping: TBA

Experimental Number: E-15413-93  
Charge Cost To: 0-042-1284 763-02  
Project No.: LR-200  
Machines Involved In Cost:  
PPDI - Saran Extrusion 3-layer  
- EB  
- Bag Machine

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Title: 3-layer Saran Sealability and Toughness

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Objective: The purpose of this E-number is to evaluate Dow Insite Polymer and modify the current 80/10/10 formulation to improve the sealability and toughness of 3-layer shrink bags.

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## Instructions:

### Materials

Saran Blend: 3653-00  
EVA, ULDPE Blend: 3652-00  
Exxon LD 712.06 (10% VA, 0.3 MI)  
Exxon LD 318-92 (9.0% VA, 2.2 MI)  
Dow XUR-1567-58462A37 (1.0 MI, density = 0.908)

### Blending

Blend 300 lbs. of inner Dow PE, EVA blends for Variables 3, 4, 5 and 6 at PTNW and ship to PPDI.

### PPDI - Saran (3-layer Die)

Produce two 4M ft. roll of each of the following structures at 13" width at 230 ga. per Spec. Z-2655.

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Estimated Cost: \$1,500.00  
Assigned To: J. Zheng  
Assisted By:

Approval: Roger L. Kaas

Date:   
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Distribution: R. Germonprez  
B. Steen  
  
L. Christenson  
K. Peterson  
S. Godsil (7) PPDI

R. Kaas  
J. Britt FFFF 06H  
K. Lind (2)  
J. Zheng (2)  
J. Eckstein

PPDI - Saran -cont.-

<u>Variable</u>	<u>Outer</u>	<u>Core</u>	<u>Inner</u>
1	3652	3653	3652
2	3652	3653	Dow XUR-A37
3	3652	3653	90/10 A37/712.06
4	3652	3653	80/20 A37/712.06
5	3652	3653	50/50 A37/712.06
6	3652	3653	80/10/10 712.06/A37/318.92
Total Gauge 230	100~130 ga.	20 ga.	80~110 ga.

PPDI - EB Line

1. EB 1 roll each variable to 4.0 Mrad per Spec. M-808.
2. EB 1 roll each variable to 5.3 Mrad per Spec. M-811.

PPDI - Bag Machine

Produce 500 13 X 26" bags each variable per Spec. B-1233  
(12 total cartons)

Testing

PPDI per Spec. Z-2655, M-808, M-811 and B-1233  
PTNW per J. Zheng